



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D4931-1 Job Sheet 189913



Part No: D4931-1

Job Qty: 10 pcs

Part Name: Engine Fitting (for acft models B2 & previous)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/19

Job Tracking No:

Due Date: 3/4/19

Created By: Dara Macdonald

Type: ~~SOLD~~ STOCK

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 13-09-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs	3/4/19	3/4/19	0.00	12.50	Doosan - 1		PMP 2019-03-21
110	QC 2	10 pcs	3/4/19	3/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		PMP 2019-03-21
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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CANADA
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DART
AEROSPACE
Container No: S165355
Part: D4931-1
Job No: 189913
Serial No/Batch: S165355
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 03/22/19

120	QC 8	10 pcs	3/4/19	0.00	0.00	QC 2 - 8	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 38	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	B.e 19-03-29
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
130	Packaging 3-2 - Stock - B4B	10 pcs	3/4/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	5127 SA APR 01 2019
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
140	QC 21 - SA	10 pcs	3/4/19	0.00	0.00	QC 21 - SA - 21	DAS 21 APR 01 2019

Part Op **100** - (Doosan Lathe) Machine as per folio FB210
Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - QC8- Inspect parts - second check)
130 - Identify as per dwg & Stock Location: _____)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	2.5000 ft (.25 ea) (.167)	100-Doosan - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R2.000	3	16	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:
Description: EAPS P2 Engine Fitting		Part Number: D4931-1
Inspection Dwg: D4931 Rev: A		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06 x 45°	+/-0.030 x +/-0.5°	.058 x 45°				
0.362	+/-0.010	.360				
0.088	+/-0.010	.090				
0.08	+/-0.030	.078				
0.25	+/-0.030	.250				
0.50	+/-0.030	.499				
Ø0.063	+0.004/-0.001	.064				
0.125	+/-0.010	.120				
0.424	+/-0.010	.430				
0.315	+/-0.010	.309				
0.185	+/-0.010	.179				
37°	+/-0.5°	37.3				
1.283	+/-0.010	1.282				
1.250	+/-0.010	1.250				
Ø0.472	+0.006/-0.001	.475				
Ø0.670	+0.008/-0.001	.666				
0.500	+/-0.010	.501				
0.950	+/-0.010	.948				
Ø0.609	+0.008/-0.001	.609				
0.938	+0.000/-0.005	.936				
1.804 Ref	+/-0.010	1.813				
1-1/16-12 UN 2A	N/A					
M18 x 1.5 Thread	N/A					
Wire Size 0.55	Max 1.099 ⁵ Min 1.093 ⁸	1.0955				
Wire Size 0.040	Max 0.737 ⁸ Min 0.732 ³	.7345				

Measured by: PMP DAS 56	Checked by: B.e	QC Inspector:
Date: 2019-03-29	Date: 19-03-29	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.08.27	New Issue	KJ	
B	16.05.30	Dimensions updated	KJ	